



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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DSK076

Job Sheet 192370



Part No: DSK076

Job Qty: 6 pcs *10 onf*

Part Name: D2891-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 4/12/19 *April 30*

Created By: Marie Lajeunesse

Type: SOLD *SOLD*

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	6 pcs	4/12/19	4/12/19	0.06	4.03	Doosan - 1		<i>19/03/28</i>
110	QC 2	6 pcs	4/12/19	4/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		<i>19/03/28</i>
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S167691



Part: DSK076

Job No: 192370

Serial No/Batch: S167691

Revision:

Inspector:

Exp Date:

Instructions:

Date: 03/28/19

120	QC 8	6 pcs	4/12/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mark 14/03/19
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
130	Packaging 3-1 - Stock - B4B	6 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	mark 14/03/19
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	6 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-25

Part Op 100 - Turn blank for as per Folio FA046 DT8671
 Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8 Machining-4 (QC8- Inspect parts - second check)
 130 - Packaging3-2 (Identify as per dwg & Stock Location: ML LOCATION: MAT060)
 140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6104-003	Round Billet, 17-4	6 pcs (1 ea)	100-Doosan - 1	5150871

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6104-003	6	21	0

Part Specifications
Specifications could not be found.

Plex 3/22/19 7:27 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 192370
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.274	2.275	2.276	2.278	2.277
B	3.702	3.722		3.711	3.711	3.711	3.711	3.711
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		0.730	0.730	0.730	0.730	0.730
E	0.090	0.110		0.100	0.100	0.100	0.100	0.100
F	2.464	2.484		2.474	2.472	2.474	2.474	2.474
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		0.923	0.923	0.923	0.923	0.923
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.090	0.110		0.098	0.098	0.098	0.097	0.098
L								
M								
N								
O								
P								

Measured by: [Signature]	Date: 19/03/28
Audited by: [Signature]	Date: 19/03/29
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]

DART AEROSPACE LTD		Work Order:	192370
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	$\neq 6$	$\neq 7$	$\neq 8$	$\neq 9$	$\neq 10$
Lathe Section								
A	2.274	2.279		2.277	2.278	2.277	2.277	2.277
B	3.702	3.722		3.711	3.711	3.711	3.711	3.711
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		0.730	0.730	0.730	0.730	0.730
E	0.090	0.110		0.100	0.100	0.100	0.100	0.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		0.923	0.923	0.923	0.923	0.923
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.090	0.110		0.098	0.098	0.098	0.098	0.098
L								
M								
N								
O								
P								

Measured by: *[Signature]* Date: 19/03/28

Audited by: *[Signature]* Date: 14/03/29

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					